

Date: Friday, 12/06/2009 9:54:07 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT	
Job Number	: 48533		Part Number	: D2562001	
Estimate Number	: 10272		Drawing Number	: D2562 REV D	
P.O. Number	:		Project Number	: N/A	
This Issue	: 12/06/2009	S.O. No. :	Drawing Revision	: D	
Prsht Rev.	: NC		Material	:	
First Issue	: //	Type	: SMALL /MED FAB		
Previous Run	: 48108		Due Date	: 24/06/2009	Qty: <u>3</u> Um: Each
Written By	:				
Checked & Approved By	: <u>JUL 09.06.12</u>				
Comment	: Est F 02.04.15 Added dwg Rev.B1 NG				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0500W035	304 RD Tube .500 x .035W
Comment: Qty.: 1.7920 f(s)/Unit Total : 14.3363 f(s) 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall Batch <u>M111097</u>		<i>m / 09/06/23</i>
2.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Punch to length as per Dwg D2562		<i>m / 09/06/23</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL/MED FAB RESOURCE 1- Bend end as per Dwg D2562 Angle "D" 2-Deburr		<i>m / 09/06/23</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>S09/06/23 (t3)</i>
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3		<i>M111472</i>
START TIME:	<u>3:20pm</u>	
OVEN TEMPERATURE:	<u>320°f</u>	
FINISH TIME:	<u>3:50pm</u>	
		<i>910 09-06-23 X3</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M. H 09/06/23



(3X)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 764

9/6/23

SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (6)

Job Completion



C 209/06/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

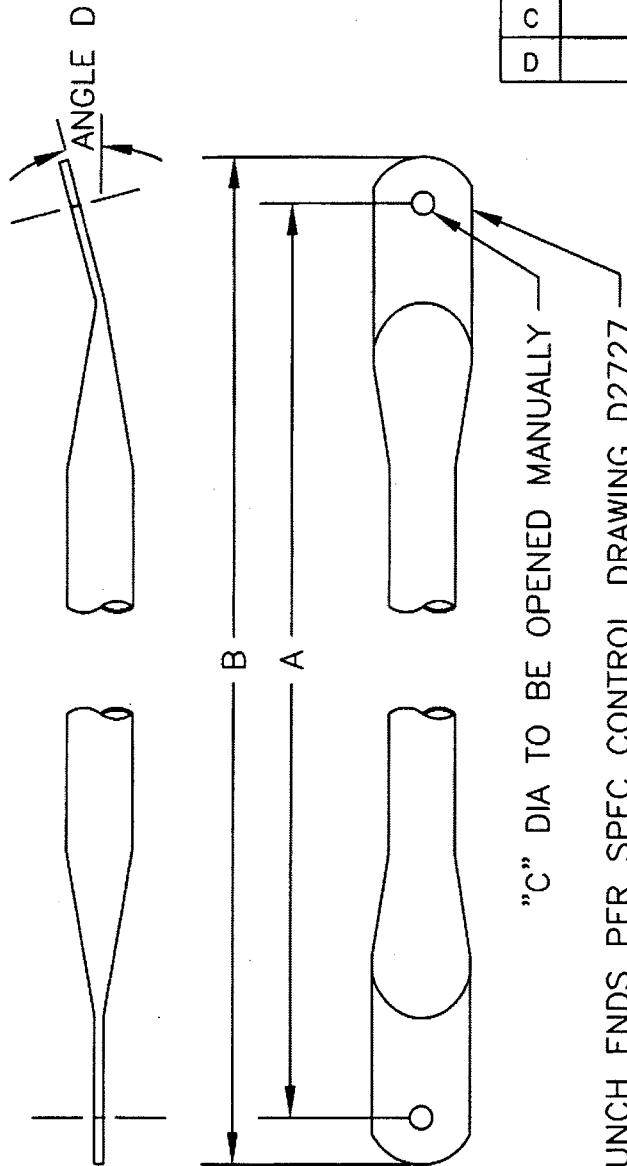
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
BY VIOLET NOTICE

WITHOUT NOTICE
WORK ORDER

WORKS
1949-53

NO. 18

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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